

Work Order ID 58476

May 7, 2010 10:24:52 AM



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Item ID: D206-559-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 07/05/2010 Start Qty: 400

Required Date: 14/05/2010 Req'd Qty: 400

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *H*

Date: 10-5-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D206-559

J -PRELIM

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPPD206-559-011 CHG006

8/06/11

for BG 10/06/11

160

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

= 7 m. 10/06/11

170

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/06/11

(44)

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Item ID: D206-559-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 07/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-559-011 □ Location: <u>Rev B</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

10/06/14 (y)

10/06/15 JH

mf
10-6-14

Picklist Print

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Work Order ID: 58476

Parent Item: D206-559-011

Parent Item Name: Bearpaw

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM
IPP Rev:D 07-01-02 Was K10007 JLM
IPP Rev:E 08-05-05 up a chg DD verified by:EC
IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 4.00

Required Qty: 4.00

AN4-15A Purchased No 160 Each 207.0000 32x 8
Bolt

Location	Loc Qty	Loc Code
ST358	207	
114239	26	
114292	181	

AN4-17A Purchased No 160 Each 982.0000 32x 8
Bolt

Location	Loc Qty	Loc Code
ST359	982	
112314	982	

AN960JD416 Purchased No 160 Each 0.0000 16
Washer
D2182B Manufactured No 160 f 371.9138 1.666 6.66
Rubber Cushion

Location	Loc Qty	Loc Code
ST402A	9.67	
30872	9.67	
ST410	362.2438	
52649	362.2438	

(D2182B050) Cut (4) at 5.00" as per dwg ***per kit***

16x

→ measure
sideways

32x m-l 10/06/11
32x m-l 10/06/11
64x m-l 10/06/11
6.66 m-l 10/06/11

Picklist Print

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Work Order ID: 58476



Parent Item: D206-559-011



Parent Item Name: Bearpaw

Start Date: 07/05/2010

Required Date: 14/05/2010

Comments:

IPP Rev:C 04.02.17 Blank size changed KJ/JLM

IPP Rev:D 07-01-02 Was K10007 JLM

IPP Rev:E 08-05-05 up a chg DD verified by:EC

IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

D2274 Manufactured No 160 Each 689.0000 32x 8



Radius Block



S H

Location Loc Qty Loc Code

ST010 689

54850 66

56686 117

57714 ✓ 233

57912 273

32x m-l 10/06/11

S H

D2435 Manufactured No 160 Each 0.0000 2 ✓



Bearpaw, 206

~~3591~~



B59160

D2438 Manufactured No 160 Each 133.0000 4



m-l 10/06/11

S H

Clamp

Location Loc Qty Loc Code

ST456 133

55447 33

55603 ✓ 100

16x4x m-l 10/06/11

D2529 Manufactured No 160 Each 142.0000 32x 8



Washer



B58568 ✓

S H

Location Loc Qty Loc Code

ST017 142

56184 142

32x m-l 10/06/11

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Shop Packet Print

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Picklist Print

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Work Order ID: 58476

Parent Item: D206-559-011

Parent Item Name: Bearpaw

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM
 IPP Rev:D 07-01-02 Was K10007 JLM
 IPP Rev:E 08-05-05 up a chg DD verified by:EC
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L4 Purchased No 160 Each 2,408.000 32x 8



Nut

Location	Loc Qty	Loc Code
ST139	2	
111827	2	
ST300	2098	
113422	96	
114523 ✓	1994	
9063	8	
ST463	308	
114416	308	

32x m-l
10/06/11

QS200-M44S Purchased No 160 Each 10.0000 8x 2



Clamp

Location	Loc Qty	Loc Code
ST450	10	
113288 ✓	10	

8x m-l
10/06/11

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Shop Packet Print

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-15A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER
2		2					QS200M44S	CLAMP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries